

Date: Wednesday, 26/11/2008 12:46:06 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)
Job Number	: 43752		
Estimate Number	: 11000		
P.O. Number	:	Part Number	: D26021
This Issue	: 26/11/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2602 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 42144	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 10/12/2008
Checked & Approved By	: <u>JLD 08.11.26</u>	Qty:	4
Comment	: Est. D 04.02.25 Reformat KJ/RF	Um:	Each
	Note: Issue with part number D2602-2		
	Est Rev:E Now On Waterjet 07-03-22 JLM		
	Est Rev:F RevB as per dwg ECN1059 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 1.4146 sf(s)/Unit Total : 5.6582 sf(s)

2024-T3 .040 sheet

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040) Batch 107461 IB 8-12-10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2602

*****Same Cutting File for -1 & -2 *****

Dwg Rev: B IB 8-12-10

Proc Rev: B

2-Deburr if necessary IB 8-12-10

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

505/12/10 (84)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:46:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 43752

Part Number: D26021

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Debur if necessary

2-Form as per Dwg D2602

SR 08/01/05

(4)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/05 44

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AWM 9-1-06

(4)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/01/07 44

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 175

SS 09/01/07 xu

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 09.01.07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

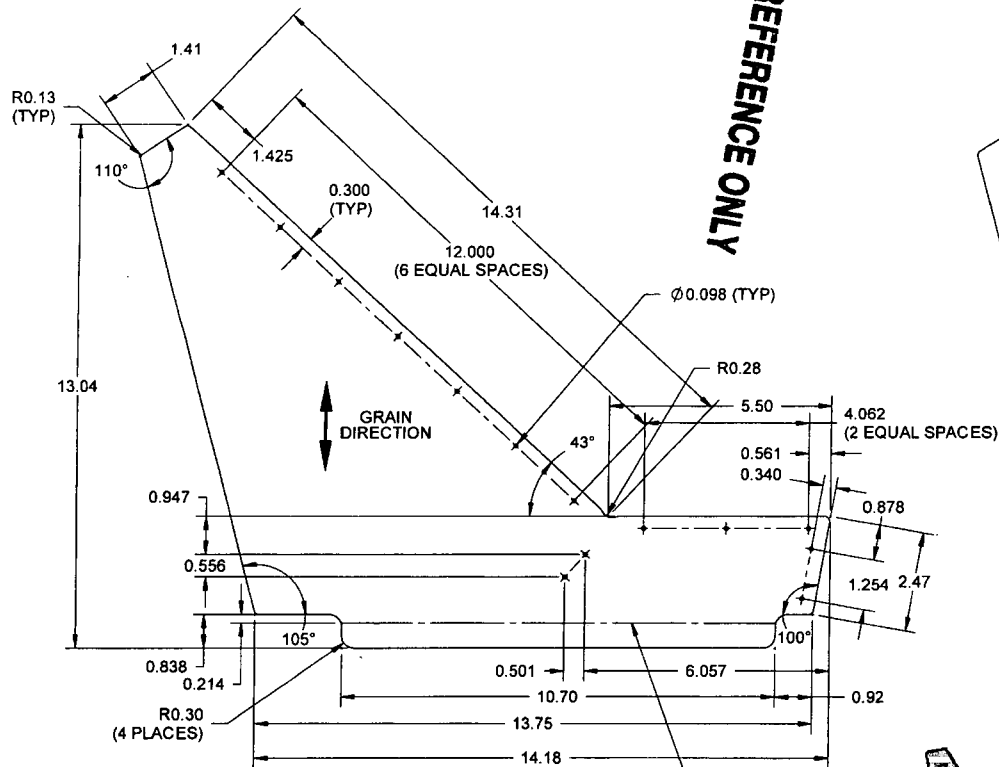
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

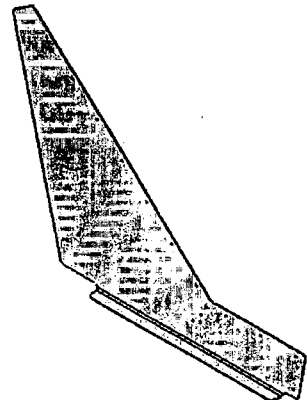
4375-2



D2602-1F FLAT PATTERN

D2602-1 CONSOLE SIDE (MAKE FROM D2602-1F)
(D2602-2 OPPOSITE)

RELEASED
07-12-12



- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.38 lbs

B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES	DC	07.11.07
A	D2602 WAS D206-547-211-22	BW	97.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	HA	D2602	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.		CONSOLE SIDE	1:3
DATE	07.11.07	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	